

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004943**Date Inspected:** 24-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

East Shaft, Lift 1

The Quality Assurance Inspector performed a survey of the progress in the confined space of the East Shaft Lift 1. QA has not had approval to enter the confined space until today. It was observed that ZPMC had welded the approximately 25 percent of the diaphragm plates to skin plates B, C, and D partial joint penetration welds. It was evident ZPMC had performed magnetic particle testing to the root pass of the welds due to the left over magnetic particles observed. The Quality Assurance Inspector observed exposed wires where a string of lights were spliced. At bottom end of the shaft it was observed there is not a ladder in place to exit or enter the shaft.

South Shaft, Skin A, Lift 2

The Quality Assurance Inspector observed ZPMC in the process of attempting to correct distortion in a longitudinal stiffener. ZPMC was utilizing several 10 ton hydraulic jacks and torches. Below is a digital photograph illustrating the procedure.

Summary of Conversations:

As stated in the contents of the above report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Josh Ishibashi 1.376.647.10411, who represents the Office of Structural Materials for your project.

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
